

Date: Thursday, 12/15/2005 3:55:44 PM  
 User: Kim Johnston

## Process Sheet

PTO Replace  
 All parts.

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : FLOOR WINDOW
Job Number : 25253	
Estimate Number : 10457	
P.O. Number : N/A	Part Number : D32121
This Issue : 12/15/2005 S.O. No. : N/A	Drawing Number : D3212 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 24752	Material : Multiples of 4
Written By : SEE COMMENT BELOW	Due Date : 1/5/2006
Checked & Approved By : SEE COMMENT BELOW.	Qty: 12 Um: Each
Comment : Est Rev: A New Issue 05-11-09 JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MLEXANS125	1/8" Lexan Sheet
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Comment: Qty.: 1.0232 sf(s)/Unit Total: 10.2323 sf(s)

Material: 0.125" Polycarbonate

(M-LEXAN-S.125)

Identify as D3212-1

Batch: M18474

M18474

SA 06.01.10 12

JL 05.12.21 12

2.0	SHEAR	SHEAR
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Comment: SHEAR

Cut blanks: 15.250" x 9.200" (+0.000/-0.010)

SA 06.01.10 12

JL 05.12.21 12

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Machine D3212-1 as per Folio FA349 and Dwg D3212Stack of 4

SA 06.01.10 12

JL 05.12.21 12

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SA 06.01.10 12

JL 05.12.21 12

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

SA 06.01.10 12

JL 05.12.21 12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: DP Date: 06/01/30  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 12/15/2005 3:55:44 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOOR WINDOW

Job Number: 25253

Part Number: D32121

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

D27281

Dart Logo label small



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Qty Part # Description Batch

1 D2728-1 Dart Logo label B24215

DL 06/01/09 12

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr

2-Install label as per Dwg D3212

3-Wrap in Plastic Wrap

DL 06/01/13 (11)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

9-9-12 9

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 96

9/1/27 (9)

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21


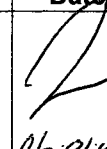
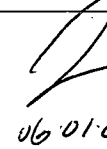
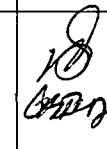
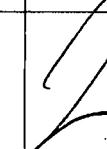
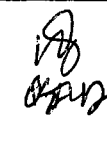
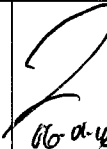

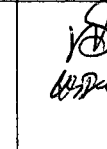
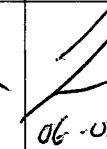
545 06/01/30 (9) 06/01/30

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3212-1 PAR #: N/A Fault Category: Red / Pass' ~~ASS~~ med-small NCR: Yes No DQA: 2 Date: 06/01/30  
 QA: N/C Closed: 18 Date: 06.01.30

NCR: <u>25253</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06-01-09	7	All windows were found with scratches on them. Scratches from ASS'P and most through the plastic film, from the start.		Scrap: destroy/stack Replace on this w/o.	 06-01-09	 06-01-09		 06-01-09
06-01-16	7	2 have long fine scratches across the whole windows.		Scrap: destroy.	 06-01-16	 06-01-16		 06-01-16

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	25253
<b>Description:</b> Floor Window		<b>Part Number:</b>	D3212-1
<b>Inspection Dwg:</b> D3212 <b>Rev:</b> A		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
12.734	+/-0.005	12.733	✓			<del>Cant measure accurately</del>
6.367	+/-0.005	6.366	✓			
0.625	+/-0.005	.625	✓			
0.156	+0.005/-0.000	.157	✓			
R0.25	+/-0.030	.25	✓			
8.150	+/-0.005	8.150	✓			
3.750	+/-0.005	3.749	✓			
0.313	+/-0.010	.313	✓			
15.14	+/-0.030	15.141	✓			
12.520	+/-0.005	12.519	✓			
6.260	+/-0.005	6.259	✓			
1.312	+/-0.005	1.312	✓			
0.313	+/-0.010	.314	✓			
3.750	+/-0.005	3.749	✓			
8.150	+/-0.005	8.149	✓			
8.462	+/-0.005	8.461	✓			
9.09	+/-0.030	9.089	✓			

*Notes are on angle*

<b>Measured by:</b>	J.L	<b>Audited by:</b>	Er	<b>Prototype Approval:</b>	N/A
<b>Date:</b>	05.12.20	<b>Date:</b>	05/12/21	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	03.12.15	New Issue	KJ/RF	

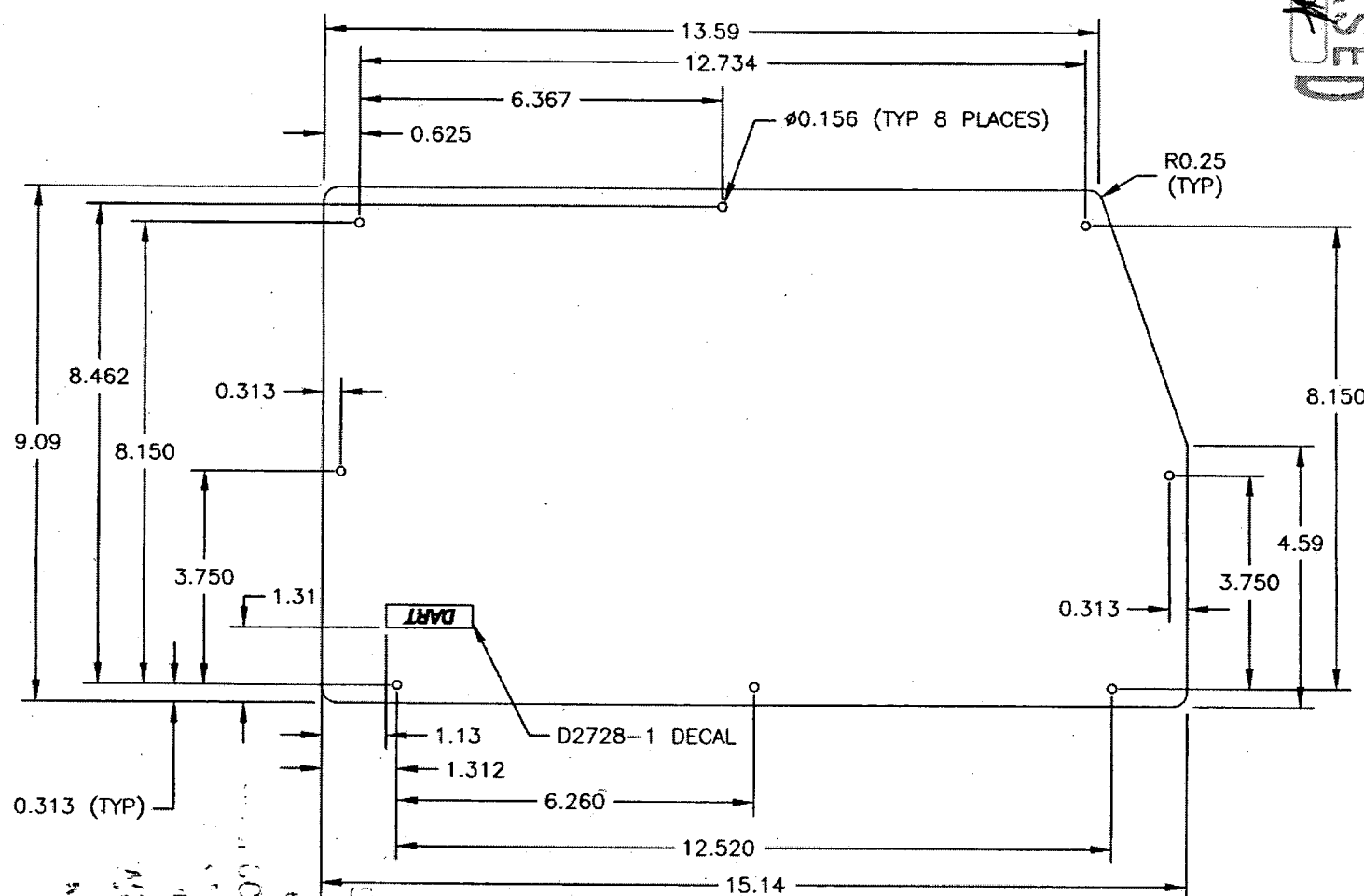
**DART**



DESIGN	IS	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	#	APPROVED	#	DRAWING NO.	D3212
DATE	03.09.03			TITLE	FLOOR WINDOW
A		03.09.03		NEW ISSUE	
				REV. A	SHEET 1 OF 1
				SCALE	1:3

RELEASED  
03.09.03

D3212-1 FLOOR WINDOW  
MACHINE PER DRAWING FILE "D3212-A1.DWG"  
CHECK WITH TEMPLATE D3212-1T1  
DIMENSIONS ARE FOR REFERENCE ONLY  
MATERIAL: 1/8" CLEAR POLYCARBONATE  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



RECEIVED  
ENGINEERING  
25253

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DART AEROSPACE LTD		Work Order:
Description: <i>Rear Window</i>		25253
Inspection Dwg:		Part Number:
Rev:		23212-1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Co
12.734	$\pm .005$	12.730			Tape	
6.367	$\pm .005$	6.369	/			
0.625	$\pm .005$	.625	/			
.156	$\pm .005$	.157	/			
R. 25	$\pm .030$	R. 25	/			
8.150	$\pm .005$	8.154	/			
3.750	$\pm .005$	3.750	/			
.313	$\pm .010$	.314	/			
15.14	$\pm .030$	15.14	/		Tape	
12.520	$\pm .005$	12.520	/		Tape	
6.260	$\pm .005$	6.258	/			
1.312	$\pm .005$	1.317	/			
.313	$\pm .010$	.314	/			
3.750	$\pm .005$	3.751	/			
8.150	$\pm .005$	8.150	/			
8.462	$\pm .005$	8.466	/			
9.09	$\pm .030$	9.092	/			

Measured by: <i>SD</i>	Audited by: <i>SG</i>	Prototype Approval:
Date: <i>06.01.10</i>	Date: <i>06.01.10</i>	Date:

Rev A	Date	Change New Issue	Revised by KJ/RF
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